Date

Thursday, 22/03/2007 3:19:57 PM

User:

Linda Lacelle

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

**Job Number Estimate Number** 

: 31333 : 11001

P.O. Number

- NIA

This Issue

: 22/03/2007

S.O. No. : 1)A

Prsht Rev. First Issue

: 31333

: SMALL /MED FAB

**Previous Run** Written By

**Checked & Approved By** 

Comment

E 04.02.25 Reformat KJ/RF Issue with part number D2602-1 Note:

Est Rev:E Now On Waterjet 07-03-22 JLM

**Drawing Name** 

: CONSOLE SIDE LH (206 HI-SLOPE)

**Part Number** 

: D26022

**Drawing Number** 

D2602 REV A1

**Project Number Drawing Revision**  : N/A : A1

Material **Due Date**  :NA : 10/04/2007

Qty:

10 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M2024T3S040



2024-T3 .040 sheet



Comment: Qty.:

1.4146 sf(s)/Unit Total: 14.1456 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040) Batch M104005



2.0

WATER JET





FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2602

\*\*\*\*\*\*\*Same Cutting File for -1 & -2 \*\*\*\*\*

Dwg Rev: A Prog Rev: 41

ml 07 04 20



2-Deburr if necessary



3.0

QC2







Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK



Page 1

Date: Thursday, 22/03/2007 3:19:57 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE) Job Number: 31333 Part Number: D26022 Job Number: Seq. #: **Machine Or Operation: Description:** BRAKE NC NC BRAKE 5.0 Comment: NC BRAKE SAN ETLOUIZY (W Deburr Form as per Dwg D2602 6.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING1 HAND FINISHING RESOURCE #1 7.0 Comment: HAND FINISHING RESOURCE #1 10 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 10 PACKAGING RESOURCE #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_\_ 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL IN SPECTION/W/O RELEASE Job Completion

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Date: , r Tuesday, 3/20/2007 12:03:24 PM User: Kim Johnston **Process Sheet** Customer : CONSOLE SIDE LH (206 HI-SLOPE) : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number 30 : 31332 **Estimate Number** : 11000 P.O. Number Part Number : D26021 This Issue : 3/20/2007 : D2602 REV A1 **Drawing Number** S.O. No. : : N/A : NC Prsht Rev. Project Number First Issue : 11 Type : MACHINED PARTS **Drawing Revision** : A1 : 25471 Material **Previous Run** : 4/10/2007 Qty: 10 Um: Each **Due Date** Written By Checked & Approved By : Est. 04.02.25 Reformat KJ/RF Comment Note: Issue with part number D2602-2 Additional Product Job Number-Description: Seq. #: 475 2024-T3 .040 sheet M2024T3S040 1.0 Comment: Qty.: Total: 14.1456 sf(s) 1.4146 sf(s)/Unit 2024-T3 .040 sheet Each Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch 2.0 SHEAR ·iti. Comment: SHEAR Ų. Cut Blank per template DT8243 HAAS CNC VERTICAL MACHINING #1 HAAS1 3.0 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA145 and Dwg D2602 Stack of 10 Identify as D2602-1 4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPEC PARTS AS THEY COME OFF MACHINE 5.0 QC8 SECOND CHECK Comment: SECOND CHECK

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHAI	NGES			· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
			QA: I	N/C Close	d:	_ Date: _	

	,	WORK ORDE	ER NON-CONFORMANC	E (NCR)			
Description of NC Corrective Action C		Corrective Action Section B	ve Action Section B			A	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
	STEP	STED Description of NC	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief Eng Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief	STEP Section A Initial Chief Eng Chief Eng Sign & Date Section C	STEP Description of NC Section A Initial Chief Eng Chief Eng Section B Section B Section C Secti

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:03:25 PM User: Kim Johnston **Process Sheet** Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE) Customer: CU-DAR001 Dart Helicopters Services Job Number: 31332 Part Number: D26021 Job Number: Seq. #: Machine Or Operation: Description: BRAKE NC NC BRAKE Comment: NC BRAKE Deburr Form as per Dwg D2602 70 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 8,0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 10.0. Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion 

## Dart Aerospace Ltd

W/O:		WORK ORDER CHA	NGES		-		ŗ
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAP #: Fault Catagory:	NCD: Vos	No DO	۸.	Doto	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:			WORK ORE	DER NON-CONFORMANO	CE (NCR)			
DATE STEP		Description of NC	Corrective Action Section B		Verification	Ammayal	A	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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								:

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31332
Description: Console Side LH/RH	Part Number:	D2602-1/-2
Inspection Dwg: D2602 Rev: A1	1	Page 1 of 1

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Rev	Date	Change					Revised by	Approve	d
	04.02.25	New Issue					KJ/RF	Applove	

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